

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007959**Date Inspected:** 29-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** Japan Steel Works**Location:** Muroran, Japan

<b>CWI Name:</b>	Pin-Tang Hsu		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	Tower, Jacking and Deviation Saddles	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date, 7/29/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

**WEST DEVIATION SADDLES**

W2W2 - Magnetic Particle Inspection still being conducted by NIS. Grinding of all weld profiles (contouring) in process by JSW personnel.

W2W3 - Saddle section is being welded by M.Kato 08-5018 and T.Watanabe 08-5169 assigned to welds W3Y-4U-1 and W3Y-4U-2 respectively, both joints are recognized Non-standard joints and properly qualified as such by WPS SJ-3011-7, FCAW with weld wire TM-95. The parameter verification was randomly checked by both, QC CWI Mr. Chung Fu Kuan and Mr. Pin-Tang Hsu.

**TOWER SADDLES**

T1-2 - This QA Inspector has performed a UT verification of joint 8Y-12U-4 (R1). Original reject was noted on Ultrasonic Inspection Report UTR-000809. To review method and results of this inspection refer to UTR dated 7/29/09 by this Caltrans OSM/Mets QA Inspector, Mike Brcic.

T1-3 - Current fit up of 50mm stiffener plates in process. This observation took place in Fabrication Shop #4.

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## WELDING INSPECTION REPORT

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### EAST SADDLES

E2E1 - Cast section now awaiting grinding of excess reinforcement per JSW representative Mr. Hideaki Kon, in the weld pit in Foundry.

E2W1 - Casted section is idle awaiting UT of repair welds. Located in Foundry Shop.

West Jacking Saddle - Foundry NDE technician A.Seino #82 was in process of performing wet MT of as shaped/dressed surface of casting. This cast section is located in the Foundry.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

### Summary of Conversations:

No significant conversations to report on this day.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Brcic,Michael	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

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